

Date: Monday, 05/05/2008 11:12:00 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORTING PLATE
 Job Number : 39036
 Estimate Number : 13298
 P.O. Number :
 This Issue : 05/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : // Type : R & D SM/MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-01 new issue DD verified by:EC

Part Number : D37811
 Drawing Number : D3781 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM 08.05.12
 Material :
 Due Date : 08/05/2008 Qty: 2 Um: Each

ACTIVE RECALL

Additional Product

FOR ENGINEERING USE ONLY. **PRELIMINARY ISSUE**
PROTOTYPE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S080 6061-T6 .080 Sheet



Comment: Qty.: 0.2502 sf(s)/Unit Total : 0.5004 sf(s)
 6061-T6 .080 Sheet
 batch: 107276 IB 8-5-5

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3781
 Dwg Rev: PRE-L. IB 8-5-5
 Prog Rev: PRE-L. (2)
 *****grain direction along 4.29" *****
 2- Deburr if necessary IB 8-5-5

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

5 08/05/12 (2)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Bend as per Dwg D3781

IB 08/05/13 (2)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Monday, 05/05/2008 11:12:00 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORTING PLATE

Job Number: 39036

Part Number: D37811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-counter sink holes as per dwg D3781

ml 08/05/13 X2

7.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08/05/13 (2)

08-05-14 (2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

~~FOR ENGINEERING USE ONLY~~

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.06.01 Prototype

Job Completion



MF 08-06-16

POSITIVE RECALL

EFFECTIVE

08/05/05

AUTH

L2

RELEASED

08/05/05

DATE

08.05.02

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | | | | | | |
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NOTE: Date & initial all entries

Receiving Report

Date: 8/3/06
 Supplier: Camp
 Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☒ No ☐
 Receipt: Cash ☒

Batch No: M/57276
 Dart P/O: 5777

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection 08/03/06
 Work Order

| Discrepancies | Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|---------------|-------------|-------------|------------------|-------------------|-------------------|----------------|----------|
| | M606176508 | | 128 | 144 | ✓ | over 16 | |
| | | | | | | | |
| | | | | | | | |

Initials of receiver (if shipment OK) Level 12 [Signature]

Location

Production/Admin: 08/03/06
 Date: 08/03/06
 Received/Costing: BCP 7207
 Initial: [Signature]

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

0
8
 MONTRÉAL : 514 336-4248
 FAX : 514 336-4246
 VARIO : 1 800 667-4248
 1 866 456-4242

DISTRIBUTEUR D'ACIER ET MÉTAUX SPÉCIALISÉS
 STEEL AND SPECIALTY METALS DISTRIBUTOR

On a du Savoir "FER"

TO:
 R 1 1 2000
 LTD
 STREET

| | |
|------------------------------------|-----------|
| FACTURE INVOICE | N° 186358 |
| DATE | 29/02/08 |
| BON DE LIVRAISON PACKING SLIP | N° 132095 |
| DATE DE LIVRAISON DELIVERY DATE | 29/02/08 |

| | | | |
|---------------------|-------------|---------------------|----------------|
| TERMS T 30 JOURS | TERR. 2R | REMARQUES / REMARKS | PAGE N° 001 |
|---------------------|-------------|---------------------|----------------|

| | POIDS WEIGHT | PRIX PRICE | PAR PER * | MONTANT AMOUNT |
|---------|-----------------|---------------|--------------|-------------------|
| 96 | 120 | 341.333 | CLB | 409.60 |
| 3 X 144 | 144 | 5.400 | | 777.60 |
| | 1 | 2.950 | UN | 2.95 |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

POIDS TOTAL 265
 TOTAL WEIGHT

Formplus N° 8619

PROPERTY OF "ACIER CAMP" INC. UNTIL PAYMENT IS MADE IN FULL, COMPLETE AND CASHED.
 ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER.
 LOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY
 6 PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. ANY DEFAULT IN RESPECT WITH
 ATION AND PERMITS TO THE SELLER, AT HIS CHOICE TO CLAIM FOR THE BALANCE DUE OR THE
 MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. ANY MERCHANDISE
 NOT BE RETURNED. ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE

| | |
|-------------------------|----------------|
| SOUS-TOTAL SUB TOTAL | 1190.15 |
| T.P.S. G.S.T. | 59.51 |
| T.V.Q. Q.S.T. | 0.00 |
| TOTAL | 1249.66 |

DITION MERCHANDISE RECEIVED IN GOOD CONDITION
 A/Y M/M J/D

WHER'S SIGNATURE DATE

QUALITY INSPECTION REPORT

Alcoa Inc.

PITTSBURGH, PA DAVENPORT WORKS

Ship From: RIVERDALE, IA.

This report is for the use of the purchaser of the material and is not to be used for any other purpose. It is the responsibility of the purchaser to verify the material meets the requirements of the specification. The material is not to be used for any other purpose than that for which it was purchased.

Mark J. Venable

Mark J. Venable
Director of Manufacturing Davenport Works

Robert P. Young

Robert P. Young
Quality Assurance Manager

Lot No. 493536

P.O. No. 00000

020834

Invoice No.

00000

Alcoa No. Item

4977123-3

Customer

SAMUEL SON & CO LT DCE-77123-3

Mfg Order

Page 1

Ship To:

Item Description

0.08 IN TH (+0 -.0045) X 48.0 IN W (+.046875 -.046875) (N1 A/T:6061)
T6 COIL SHEET FOR DISTRIBUTOR TOLERANCE GUARANTEED, AMS-QQ-A-250/11
250/11 AMS4027 REV M ID 2007 AGTMB209
REV 07 CMMPO19 REV D CMMPO25 REV Q CST1008 REV
D ((NOT MARKED)) LIGHTLY OILED COIL SIZES:
ID 20 IN COIL NGTS: MAX 5750 LB MAX GROSS
SKID WGT: 6000 LB QUAN TOL +/-30 %
CQR 0211084 REV 02 COST REQ 08-01-
19 *** W/E 08-01-26 ***

| Num | Package Ticket | Lot | Weight | Quantity | UOM | Pc Id/Serl |
|-----|----------------|--------|--------|----------|-----|------------|
| 1 | 603377 | 493536 | 4163 | 1 | PC | : |
| 2 | 603424 | 493536 | 4391 | 1 | PC | : |
| | | | 8754 | 2 | | |

Notes for CQR: 0211084.2

PRODUCT PRODUCED AND MARKED TO THE REQUIREMENTS OF AMS-QQ-A-250/11 ALSO MEETS THE REQUIREMENTS OF QQ-A-250/11P. PROD OCT
PRODUCED AND MARKED TO THE REQUIREMENTS OF QQ-A-250/11 P ALSO MEETS THE REQUIREMENTS OF AMS-QQ-A-250/11.

Exception to Spec CMMPO19 ; Reven: D Issue: Letter dated 2006-09-28 from AHERN, DENNIS T to BLACKIE, BILL .

Exception to Spec CMMPO25 ; Reven: Q Issue: Letter dated 2004-08-24 from STEGEMANN, JEAN to BLACKIE, B. .

Exception to Spec CST1008 ; Reven: D Issue: Letter dated 2006-12-04 from AHERN, DENNIS T to BLACKIE, BILL .

CQR: 0211084.2 -Specification Limits

| Temp | Dir | UTS | TYS | SL4D |
|------|--------------|-----|------|------|
| | | KSI | KSI | PCT |
| T6 | Long Transv. | Max | | |
| | | Min | 42.0 | 35.0 |
| | | | | 10 |

Chemical Composition

| | SI | FE | CU | MN | MG | CR | 2N | TI | Other | Other |
|-----|------|-----|------|------|-----|------|------|------|-------|----------------|
| | | | | | | | | | Each | Total Aluminum |
| Max | 0.8 | 0.7 | 0.40 | 0.15 | 1.2 | 0.15 | 0.25 | 0.15 | 0.05 | 0.15 |
| Min | 0.40 | | 0.15 | | 0.8 | 0.04 | | | | |

Alloy 6061

Lot: 493536

- Mechanical, Physical, Metallography, Quantometer Results

| Temp | Dir | Test | UTS | TYS | SL4D |
|------|--------------|------|------|------|------|
| | | | KSI | KSI | PCT |
| T6 | Long Transv. | 2 | 50.2 | 45.3 | 11 |
| | | | 50.6 | 45.3 | 11.4 |

060526

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: _____

Design Manager Approval: _____

| Quantity | Part Number | Description | Drawing Date | Material Cert Req'd? | Due Date | Comments | Date Completed |
|----------|-------------|--------------------|--------------|----------------------|---------------------|-------------|----------------|
| 5 | D3701-1F | FLOOR DOUBLER | 08.04.30 | Y | 08.05.02 | FOR TESTING | |
| 5 | D3702-1 | FORWARD DOUBLER | 08.04.30 | Y | 08.05.02 | FOR TESTING | |
| 5 | D3703-1F | AFT DOUBLER | 08.04.30 | Y | 08.05.02 | FOR TESTING | |
| 5 | D3703-3F | AFT CORNER DOUBLER | 08.04.30 | Y | 08.05.02 | FOR TESTING | |
| 5 | D3703-5 | AFT CAP | 08.04.30 | Y | 08.05.02 | FOR TESTING | |
| 1 | D3785-041 | ARMREST WELDMENT | 08.04.29 | N/A | 08.05.12 | FOR TESTING | |
| 2 | D3785-1 | TUBE | 08.04.29 | Y | WEEK OF 08.05.05 | FOR TESTING | |
| 2 | D3785-3 | BRACKET | 08.04.29 | Y | WEEK OF 08.05.05 | FOR TESTING | |
| 2 | D3785-5 | FIXTURE | 08.04.29 | Y | WEEK OF 08.05.05 | FOR TESTING | |
| | | | | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | | | | | | |

NOTE: Date & initial all entries

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: [Signature]

Design Manager Approval: [Signature]

| Quantity | Part Number | Description | Drawing Date | Material Cert Req'd? | Due Date | Comments | Date Completed |
|----------|-------------|------------------|--------------|----------------------|------------------|---|----------------|
| 1 | D3781-041 | CUSHION ASSEMBLY | 08.04.29 | N/A | 08.05.12 | FOR TESTING | |
| 2 | D3781-1 | SUPPORTING PLATE | 08.04.29 | Y | WEEK OF 08.05.05 | FOR TESTING | |
| 1 | D3781-3 | CUSHION | 08.04.29 | N | END OF MAY | GET QUOTE FROM CHESTNUT RIDGE DAN STOW WILL MAKE ONE FOR TESTS | |
| | | | | | | | |
| | | | | | | | |
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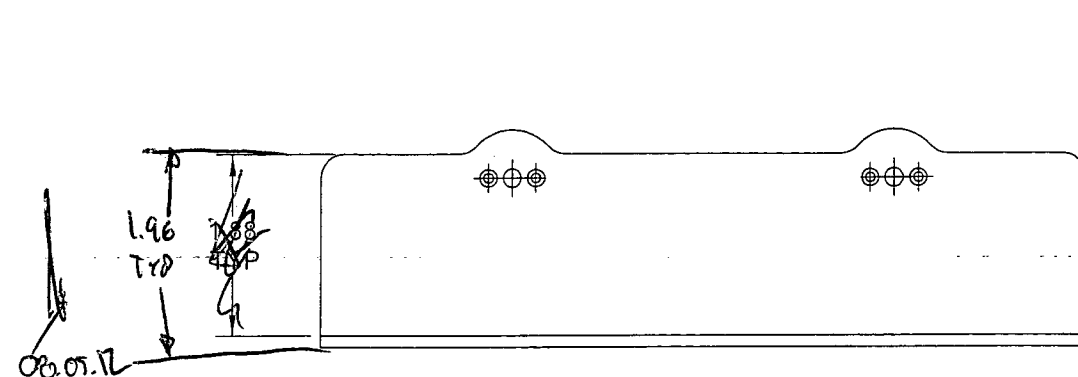
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

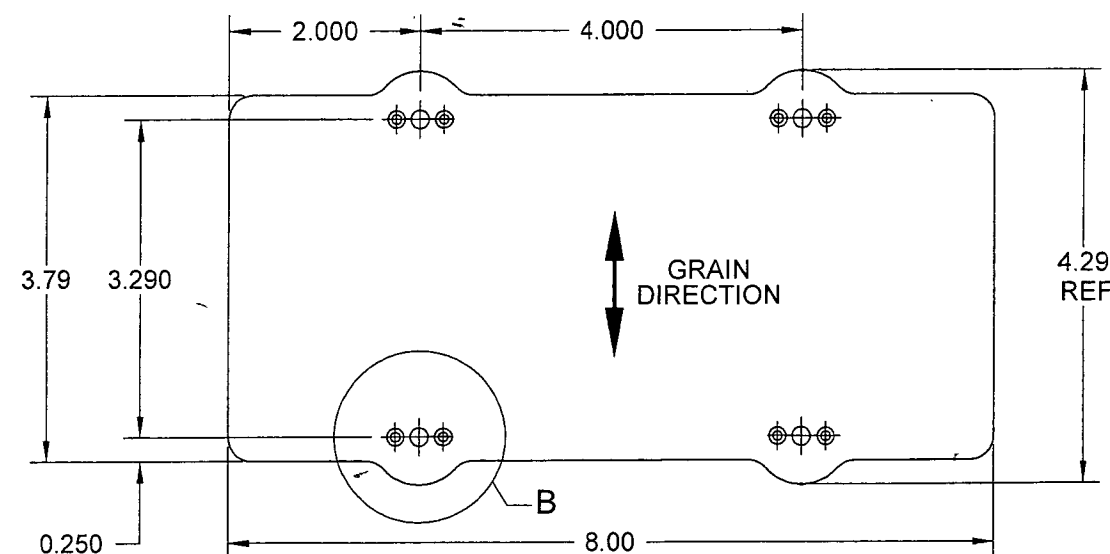
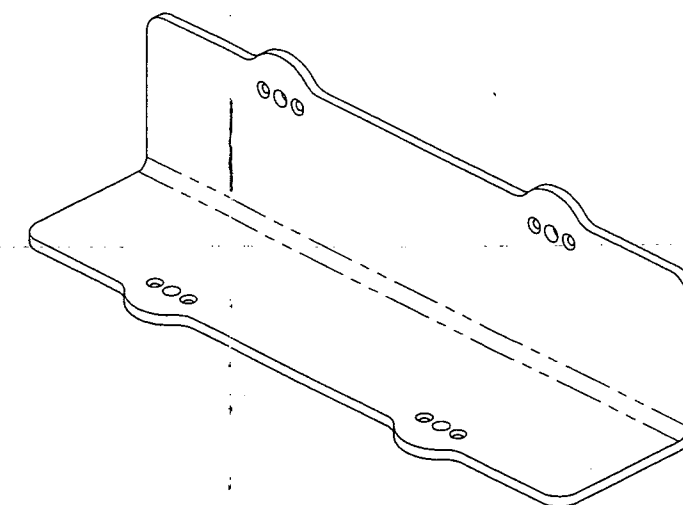
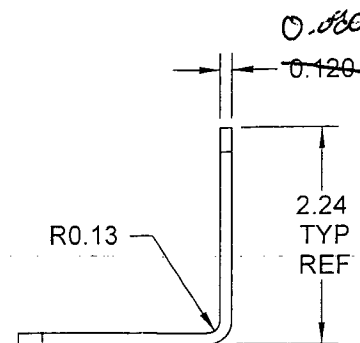
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

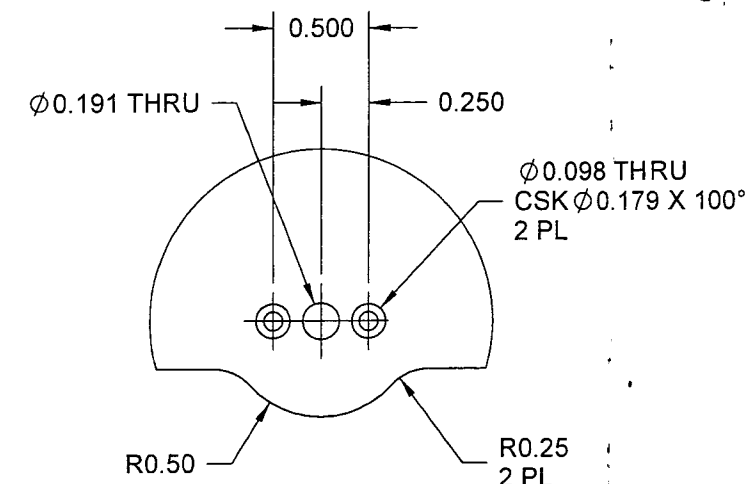


D3781-1 SUPPORTING PLATE
MAKE FROM D3781-1F



1 D3781-1F FLAT PATTERN

MS20426 83-5
M.20426



DETAIL B
SCALE 2X, 4 PL

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
PRELIMINARY ISSUE
08-04-30

D3781-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.36 lbs

| | | | |
|------------|-----------------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3781 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CUSHION ASSEMBLY | NTS |
| DATE | 08.04.29 | <small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |